

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028482**Date Inspected:** 25-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

OBG 12W

This QA observed the following welders working in OBG 12W at various locations:

Authorized welder Guo Wu Chen #1556:

Welder Guo Wu Chen was observed welding and grinding repairs on weld 12W PP115.2 W2.1-BW2 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1001-R for Shielded Metal Arc Welding (SMAW). The weld repairs were rejects noted by QC Inspector performing Ultrasonic Testing Shear Wave (UTSW). After excavation of the rejects the weld was preheated to 150 degrees Fahrenheit prior to welding.

Other welding parameters observed appear to be in compliance with the WPS noted above.

Authorized welder Richard Chounard #8959:

Welder Richard Chounard was observed welding on welds 12W PP112 W2.1-PS1 and 12W PP111.5 W2.1-BW3 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040A for Shielded Metal Arc Welding (SMAW). Both welds were preheated to 150 degrees Fahrenheit prior to welding. Other welding parameters observed appear to be in compliance with the WPS noted above.

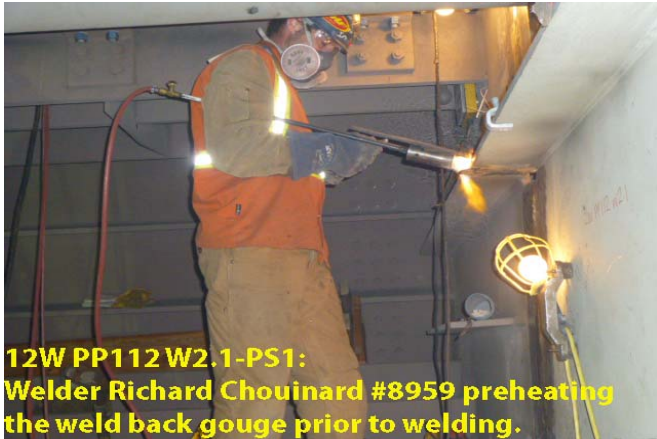
This QA observed QC Inspector Fred Michaels performing Visual Testing (VT) on joint fit ups and checking

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welding parameters such as voltage, amps and preheats throughout the day. Also noted were QC Inspector Jesus Cayabyab and Scott Krotum performing Ultrasonic Testing Shear Wave (UTSW) on weld 12W W2.1-A1 confirming reject locations from face "B" of the weld.

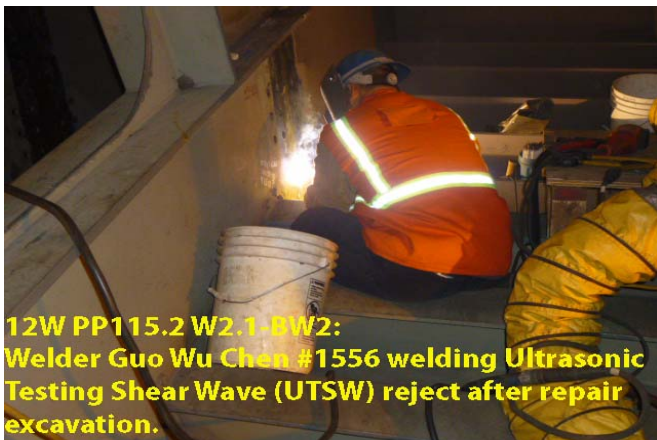
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



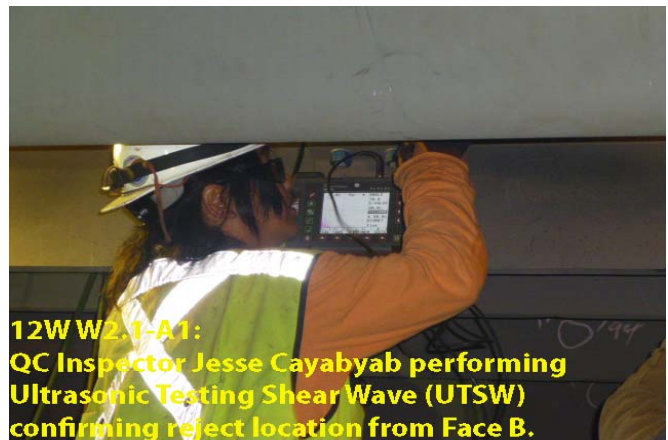
12W PP112W2.1-PS1:
Welder Richard Chouinard #8959 preheating
the weld back gouge prior to welding.



12W PP111.5 W2.1-BW3:
Welder Richard Chouinard #8959 welding
backing bar in place.



12W PP115.2 W2.1-BW2:
Welder Guo Wu Chen #1556 welding Ultrasonic
Testing Shear Wave (UTSW) reject after repair
excavation.



12W W2.1-A1:
QC Inspector Jesse Cayabyab performing
Ultrasonic Testing Shear Wave (UTSW)
confirming reject location from Face B.

Summary of Conversations:

Conversations relevant to work performed on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By: Belford,Fritz

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer
